

Date: Wednesday, 10/25/2006 11:14:56 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 155 BRACKET - UNDER REVIEW
Job Number	: 29169		
Estimate Number	: 11040		
P.O. Number	: <i>N/A</i>	Part Number	: D28042
This Issue	: 10/25/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D2804 REV <i>B</i> <i>Rev. C Preliminary Issue</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: UNDER REVIEW <i>OK</i> <i>06.10.25</i>
Previous Run	: 28310	Material	:
Written By	: <i>[Signature]</i>	Due Date	: 11/1/2006 Qty: <i>78</i> Um: Each
Checked & Approved By	: <i>[Signature]</i> <i>06.10.25</i>		
Comment	: Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on w/jetEC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
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Comment: Qty.: 0.7875 f(s)/Unit Total : 6.3000 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: *m102508 ml 06.10.27*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Template DT8534

Dwg Rev: *C*Prog Rev: *B**ml 06.10.27**(7)*

2-Deburr if necessary

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

*ml 06.10.29**7*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 06.10.29**7*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*J.L 06.10.30**(7)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/18/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/25/2006 11:14:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET - UNDER REVIEW

Job Number: 29169

Part Number: D28042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr

ml 06/10/29

7

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SL 06/10/30

⑦

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

yl

06/10/30

x7

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SB 06/10/30

⑦

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DD 06/10/30

⑦

Job Completion



U 06.10.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	29169
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804	Rev: <i>PL Preliminary Issue</i>	<i>06.10.25</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0.127	—			
0.125	+/-0.010	0.124	—			
R0.125	+/-0.010	R0.125	—			
0.250	+/-0.010	0.249	—			
0.250	+0.000/-0.005	0.249	—			
0.875	+0.000/-0.001	0.875	—			
R0.062	+/-0.010	R0.060	—			
Ø0.757	+0.005/-0.000	Ø0.758	—			
R0.625	+/-0.010	R0.625	—			
12.304	+/-0.005	12.303	—			
Ø0.507	+0.000/-0.001	Ø0.506	—			
0.437	+0.000/-0.001	0.436	—			
0.608	+0.000/-0.001	0.607	—			
Ø0.191	+0.005/-0.000	Ø0.194	—			
1.420	+0.001/-0.001	1.420	—			
0.250 deep	+/-0.010	0.249	—			
6.933	+/-0.005	6.935	—			
7.578	+/-0.005	7.576	—			
0.500	+/-0.010	0.508	—			

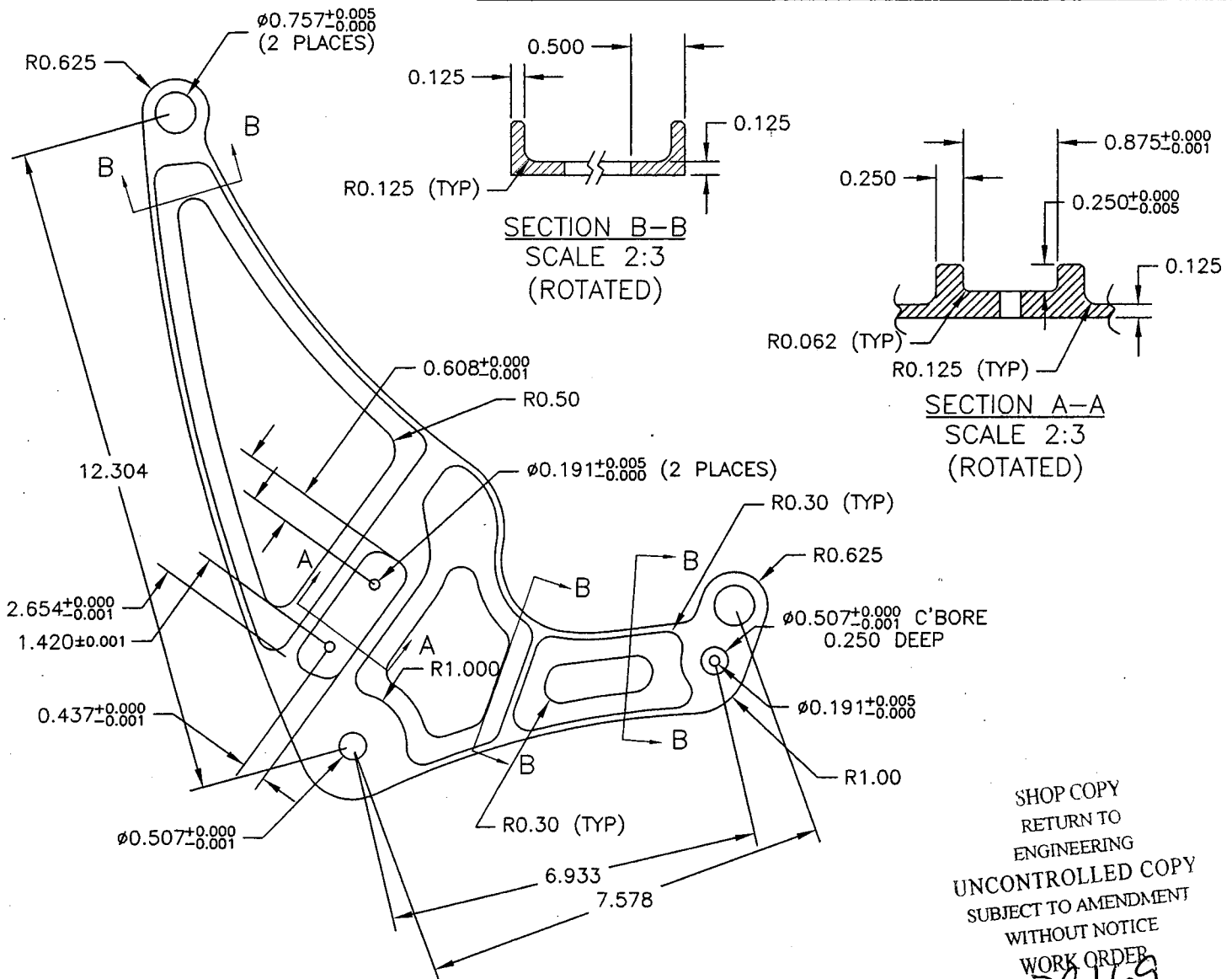
Measured by:	<i>ML</i>	Audited by:	<i>J.L</i>	Prototype Approval:	N/A
Date:	06/10/29	Date:	06/10/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM <i>JA</i>	<i>SA</i>



PRELIMINARY ISSUE

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE	06.10.16		TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07		NEW ISSUE		
B	04.11.22		ADD CUTOUTS & -043/-044		
C	06.10.16		CHANGE GEOM. TO ADD CLEARANCE		



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29169

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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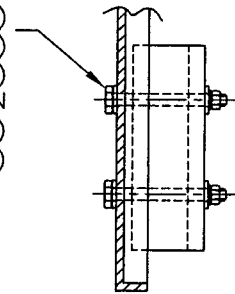
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET		SCALE 1:3

PRELIMINARY ISSUE

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21042-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2804-1 FOR D2804-041/-043
USE D2804-2 FOR D2804-042/-044

USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

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NO. 29169

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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